

Date: Tuesday, 10/3/2006 3:48:10 PM
User: Kim Johnston

Process Sheet

• 248 + .0179 = .266

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEM
Job Number : 28865A
Estimate Number : 10399
P.O. Number : N/A Part Number : D29683
This Issue : 10/3/2006 S.O. No. : N/A Drawing Number : D2968
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1
Previous Run : 28268A Material : N/A
Due Date : 10/30/2006 Qty: 22 Um: 20 Each
Written By :
Checked & Approved By : 06 10 03
Comment : Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NR0750 4130 steel rod .750"



Comment: Qty.: 0.3762 f(s)/Unit Total: 7.5243 f(s)
Material: AISI 4130 Ø 3/4 " Bar
(M4130N-R0.750) Batch: 100559
Identify AS D2968-3

06/10/10

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-Turn Blank as per Folio FA048 and Dwg D2968
2-Deburr, no sharp edges

MS 06/10/10 22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/10/10 22

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA048 and Dwg D2968
2- Deburr

06/10/15 22

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/10/15 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *2* Date: 06/10/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:48:10 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 28865A

Part Number: D29683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/10/16

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 396

Boe 10/18 (22)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

En 06/10/18

Job Completion



h 10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28865A
Description: Stem		Part Number:	D2968-3
Inspection Dwg: D2968	Rev: B1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.200	+/-0.010	4.203	✓			
3.180	+/-0.010	3.182	✓			
2.430	+/-0.010	2.432	✓			
0.470	+/-0.010	.468	✓			
0.250	+/-0.010	.255	✓			
0.550	+/-0.010	.552	✓			
Ø0.750	+/-0.010	.750	✓			
Ø0.625	+/-0.010	.620	✓			
Ø0.363	+/-0.010	.363	✓			
0.250	+0.010/-0.000	0.250	—			
0.625	+/-0.010	0.627	—			
0.150	+/-0.010	0.151	—			
1/4-28 UNF	N/A	1/4-28 UNF	✓			

Measured by: MS / [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 06/10/10	Date: 06/10/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D2968-043	KJ/RF [Signature]	[Signature]

